



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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10 Ave
Monday

D3140-303
Job Sheet 203617



Part No: D3140-303

Job Qty: 2 pcs

Part Name: Doubler



Part Weight: 0 lbs

Job Created: 11/22/19

Due Date: 11/25/19

Type: AOG

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV F IPP rev A 02.11.06 New Issue KJ/RF IPP Rev B IPP rev.C 06.04.25 Waterjet EC IPP rev.D added
scuffing NCR 061 EC IPP Rev:E As per ECN #829 06-11-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2		11/25/19	0.17	0.10	Waterjet - Flow		JRB 11/23/19
		pcs							
110	QC 2	2		11/25/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S234287

Part: D3140-303

Job No: 203617

Serial No/Batch: S234287

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/23/19

PRIORITY

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 11/23/19
120 QC 8	2 pcs	11/25/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	DAS
				QC 8 - 40	NOV 25 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - 2 - B4B	2 pcs	11/25/19	0.00 0.35	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	RD 19-11-25
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
140 QC 5	2 pcs	11/25/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	NOV 25 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	

150 Handfinish - 1-1 Chemical-B4B	2 pcs	11/25/19	0.00 0.22	QC 5 - 81	
				Handfinish - 1 - 1 - B4B	BEB 29-11-25
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 3	2 pcs	11/25/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	DAS
				QC 3 - 68	NOV 25 2019 68
				QC 3 - 9	9-89
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	2 pcs	11/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Plex 11/22/19 9:24 AM dart.lacelle.linda	

NOV 23 2019

Oscar (ST453)

Packaging 3 - 3 - B4B	✓
Packaging 3 - 4 - B4B	
Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	

180 QC 21 - SA	2 ✓ pcs	11/25/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 453
				QC 21 - SA - 70	
				QC 21 - SA - 53	DAS NOV 25 2019

Part Op 100 - 1-Cut as per Dwg D Dwg Rev: F Prog Rev: F 2-Deburr if necessary
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - 1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr. No sharp edges
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location:)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	5.5554 sf (2.7777 ea)	100-Waterjet - Flow - 1	52271116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	6	362	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	48.570inches ± 0.030	48.600 48.540		
2	Doubler	7.140inches ± 0.030	7.170 7.110		
3	Doubler	0.063inches ± 0.010	0.073 0.053		